

Work Order ID 72677

Friday, August 05, 2011 8:37:42 AM



Page 1

Item ID: DSK076

Accept



Setup Start



Revision ID: -

Item Name: D2891-1 TURNING DETAIL

Stop



Start Date: 8/5/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 8/8/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-08-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSK076	Rev A

100-	DOOSAN LATHE	0.00
------	--------------	------



Doosan

Memo

0.00

Doosan Lathe

Turn blank for as per Folio FA046

and 11/09/12

10

10

110	QC2- Inspect parts off machine FAI/FAIB	0.00
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QC

Memo

0.00

Quality Control

and 11/09/12

10

10

120	QC8- Inspect parts - second check	0.00
-----	-----------------------------------	------



QC

Memo

0.00

Quality Control

SL 11-09-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and Stock in Kanban Location: MAT 050

Jh 11-09-19

140

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

11/9/19 [Signature]
mf 11-09-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, August 05, 2011 8:37:48 AM

Page 1

Work Order ID: 72677



Parent Item: DSK076



Parent Item Name: D2891-1 TURNING DETAIL

Start Date: 8/5/2011

Required Date: 8/8/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6104-003

Manufactured

No

Each

4.0000

10



Round Billet, 17-4

Location

Loc Qty

Loc Code

MAT043

4

60943

3

66960

1

72807

amf 8/5/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	72677
Description: Turning Detail for D2891-1		Part Number:	DSK076
Inspection Dwg: DSK076		Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET


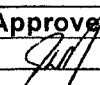
☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.274	2.279		2.276	2.277	2.278	2.278	2.278
B	3.702	3.722		3.713	3.713	3.716	3.714	3.714
C	2.564	2.584		2.574	2.573	2.575	2.575	2.575
D	0.718	0.738		.726	.726	.726	.726	.726
E	0.090	0.110		.102	.102	.102	.102	.102
F	2.464	2.484		2.474	2.474	2.474	2.473	2.472
G	2.029	2.049		2.040	2.040	2.040	2.040	2.040
H	2.964	2.984		2.975	2.974	2.975	2.974	2.974
I	0.913	0.933		.924	.924	.927	.923	.921
J	0.022	0.042		.031	.031	.031	.031	.031
K	0.090	0.110		.097	.099	.099	.099	.099
L								
M								
N								
O								
P								

Measured by:  **Date:** 11/9/16

Audited by:  **Date:** 11-09-19

Prototype Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM 	

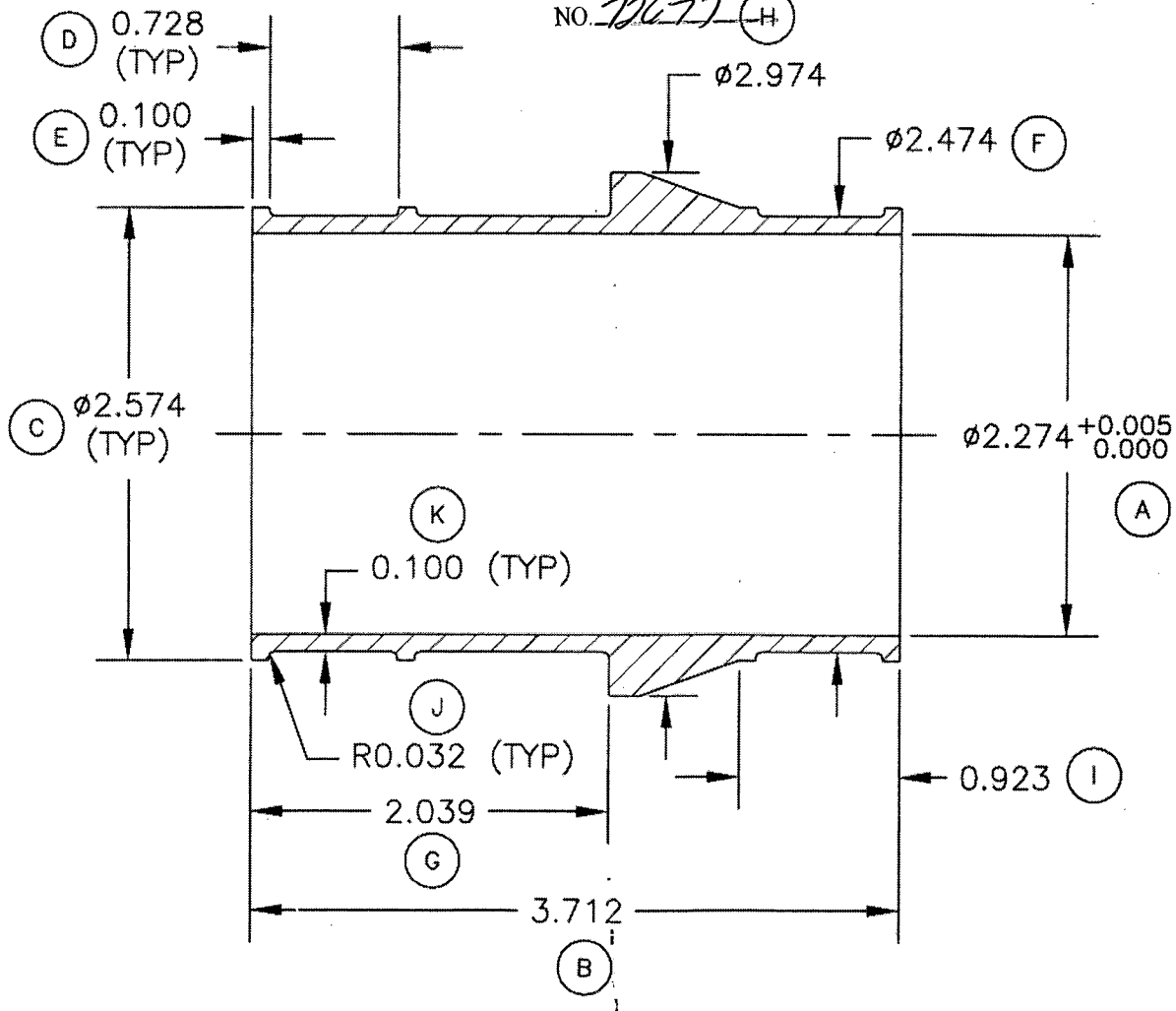


DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. DSK 076	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2891-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01 H

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 2677 (H)

PL 11-08-5



D2891-1 TURNING DETAIL

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